

# DART SERVICE INSTRUCTION

**TO AMEND INSTALLATION INSTRUCTIONS IIN-D058-676 REV. A AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D058-676 REV. 0**  
REF: FAA STC: SR01018SE

For D058-676-101/-201 crosstubes at CHG 002 or later, the D2856-400-694 abrasion strips have been removed, the D2891-1 supports have been bonded onto the crosstube using Magnabond 6398 and D3595-063-395 Rubber Cushions have been installed underneath the MS21920-20 Clamps. Amend parts list of the IIN-D058-676 Section 5 and ICA-D058-676 Section 32.8 as follows:

## REMOVE:


ITEM	QTY -101	QTY -201	PART NUMBER	DESCRIPTION
11	2	2	D2856-400-694	ABRASION STRIP

## ADD:

ITEM	QTY -101	QTY -201	PART NUMBER	DESCRIPTION
16	4	4	D3595-063-395	RUBBER CUSHION

**To prevent the supports from shifting on the D058-676-101/-201 crosstubes at CHG 001, the D2891-1 supports should be removed and re-installed as follows:**

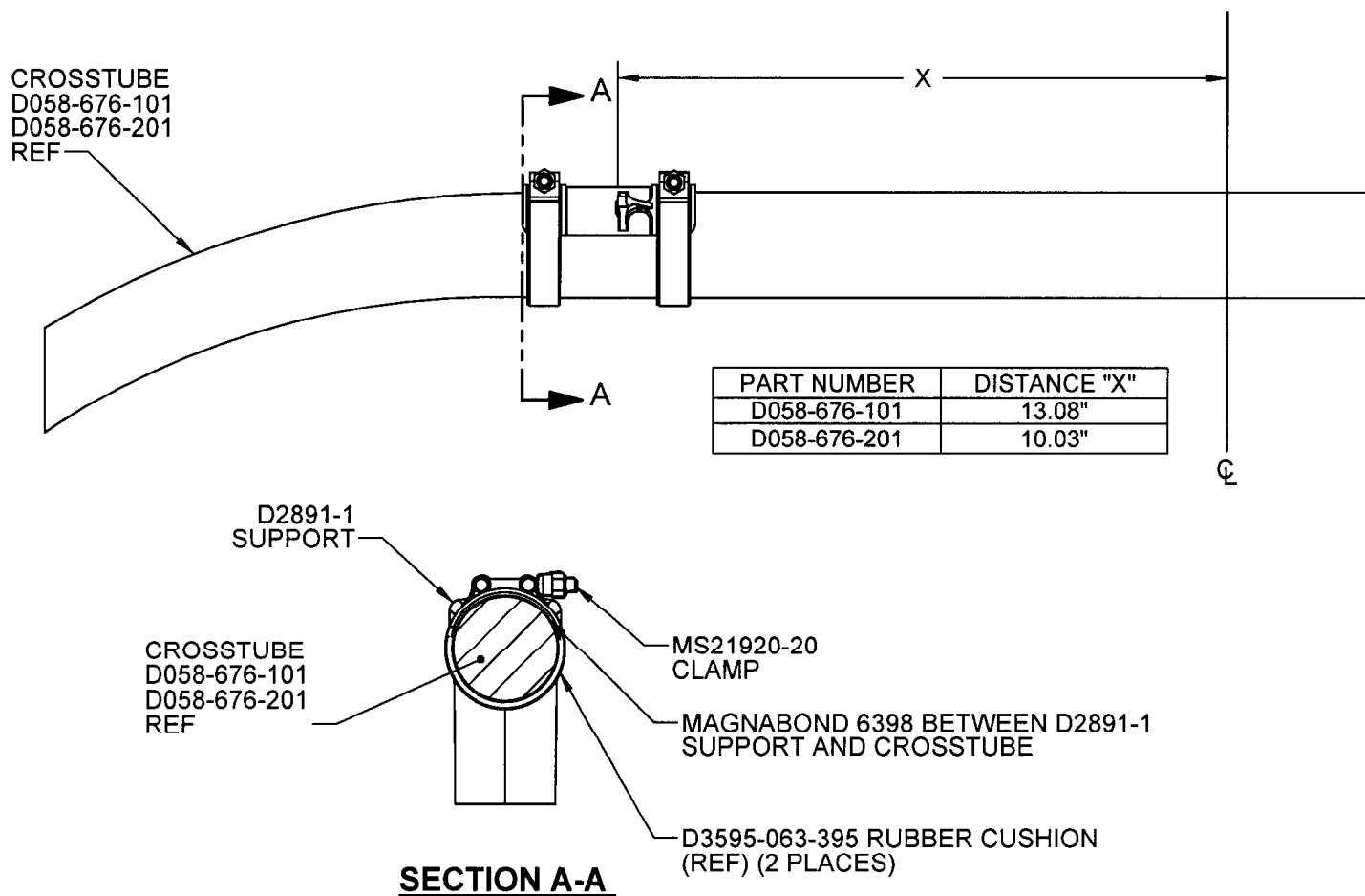
- 1) Follow section 32.1 of ICA-D058-676 for the removal of the crosstubes from the helicopter.
- 2) Remove the qty (2) MS21920-20 clamps from the crosstube that fasten each D2891-1 support to the crosstube.
- 3) Remove the D2856-400-694 abrasion strips from the crosstube per section 32.5 of ICA-D058-676.
- 4) Inspect the crosstube surface underneath each support for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection of ICA-D058-676. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection in ICA-D058-676. Touch up finish per item 5.3.9 of the 300 hour inspection.
- 5) Abrade area to which support will be applied with 400 grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe area until there is no residue.
- 6) Apply a 0.03" to 0.06" thick layer of Magnabond 6398 underneath each D2891-1 support and re-install the support on the crosstube as shown in Figure 1. Position and secure the D2891-1 supports on the crosstube using MS21920-20 Clamps. Install a D3595-063-395 Rubber cushion underneath each MS21920-20 Clamp. Torque clamps 80-100 in-lb. Let the D058-676-101/-201 crosstube assembly cure as per the Magnabond 6398 instructions before re-installing the crosstube on the aircraft.

A	NEW ISSUE	RF	08.11.06
REV.	DESCRIPTION		BY DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	DS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9425	SHEET 1 OF 2
APPROVED	DS	TITLE	SCALE
DE APPR.		CROSSTUBE SUPPORT CHANGE	NTS
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7) Re-install the D058-676-101/-201 crosstube per section 32.2 of ICA-D058-676.

For customers who would like to upgrade their D058-676-101/-201 crosstubes from CHG 001 or earlier to CHG 002, the following kit can be obtained from Dart:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9425-011	CROSSTUBE SUPPORT CHANGE (USABLE ON D058-676-101/-201)
4	D3595-063-395	RUBBER CUSHION



**FIGURE 1 - CROSSTUBE SUPPORT**

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	DS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9425	SHEET 2 OF 2
APPROVED	DS	TITLE	SCALE
DE APPR.		CROSSTUBE SUPPORT CHANGE	NTS
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